

Date: Thursday, 3/8/2007 1:21:00 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	WEARPAD
Job Number	31134		
Estimate Number	12782		
P.O. Number	N/A	Part Number	D35643
This Issue	3/8/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D3564 REV A
First Issue	N/A	Project Number	N/A
Previous Run	N/A	Drawing Revision	A
Written By	<u>Kim</u>	Material	N/A
Checked & Approved By	<u>100703.08</u>	Due Date	3/15/2007
Comment	Est Rev:A New Issue 07-03-08 ec	Qty:	6
Um:	Each		

Additional Product

Job Number:



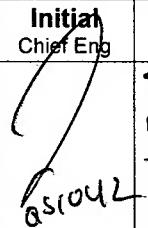
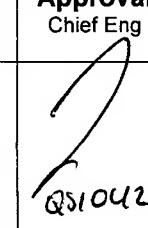
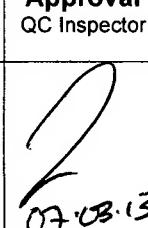
Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet
		Comment: Qty.: 0.9177 sf(s)/Unit Total : 5.5062 sf(s) M304S16GA Stainless steel sheet 0.063" thick. Batch: <u>M7106</u>
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3564 ****(D3564-1F)**** Dwg Rev: <u>A</u> Prog Rev: <u>A</u>
		2-Deburr if necessary
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK
5.0	BRAKE NC	NC BRAKE
		Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT and DT
		Form Joggles (1) as per Dwg D3564 on brake using Jig DT <i>2nd Joggle</i> <i>07-03-13</i>

(P)

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/03/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/03/13	5.0	Joggle, starts at 30.250°, and needs to start @ 30.50. wear plates don't fit on tube. operator error.	 QS1042	Flatt out the joggle and re-do at 30.5 as per the Dwg.	SPB 07/03/13	 07/03/13	 QS1042	 07.03.13

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 31134

Part Number: D35643

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

Mo7/03/13 (6)

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty	Description	Batch
A/R	2059B Hardcoat	M102755
Weld hardcoat as per Dwg D3437		

FC 09 03 13 (6)

8.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Mo7/03/13 (6)

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Mo7/03/13 (6)

10.0 POWDER COATING

POWDER COATING



m101601

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FL/M.J 07/03/14 (6)

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Mo7/03/15 (6) C

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Dylosp/56 C

13.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Mo7/03/15 (6)

Job Completion



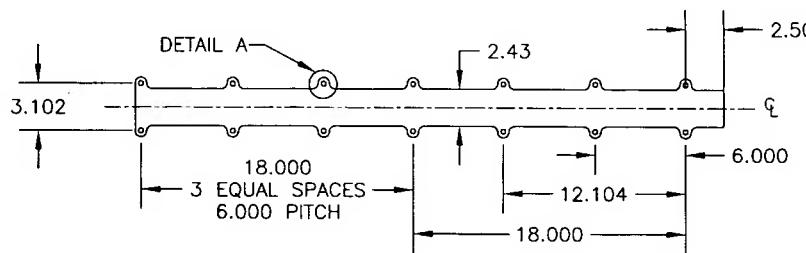
n 07/03/15

W/O:		WORK ORDER CHANGES					
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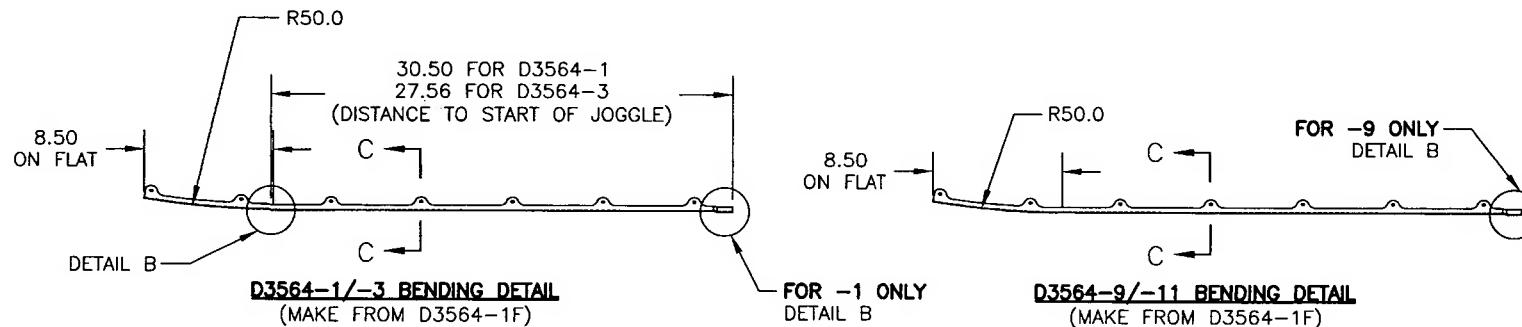
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

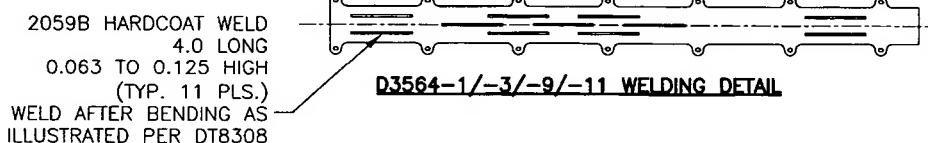


D3564-1F FLAT PATTERN



D3564-1/-3 BENDING DETAIL
(MAKE FROM D3564-1F)

D3564-9/-11 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-1/-3/-9/-11 WELDING DETAIL

D3564-1/-3/-5/-7/-9/-11/-13 WEARPLATE NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) PART IS SYMMETRICAL ABOUT CENTERLINE

NO. 31134
WORK ORDER
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A	06.12.18	NEW ISSUE
DESIGN	DRAWN BY	DART
P4	P4	DART
CHECKED	APPROVED	DRAWING NO.
<i>[Signature]</i>	<i>[Signature]</i>	D3564
DATE	TITLE	SCALE
06.12.18	WEARSHOE	1:8

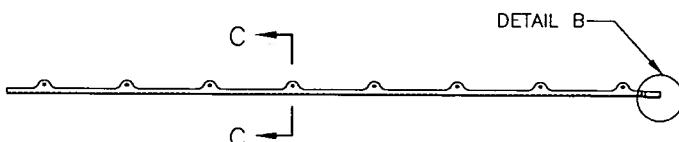
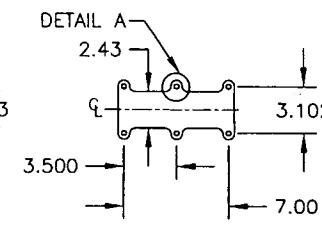
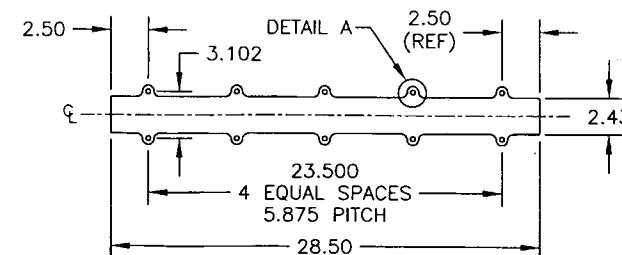
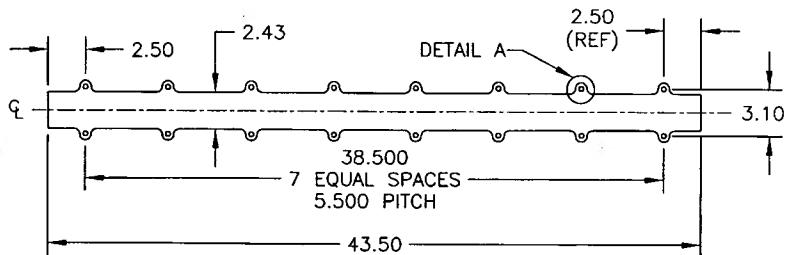
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07-07-28 #

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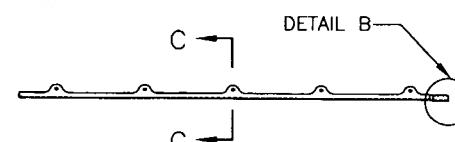
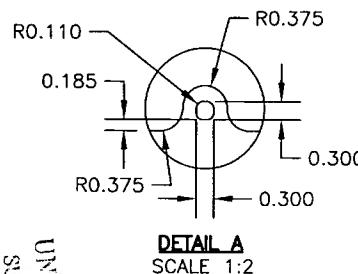
REV. A

SHEET 1 OF 2

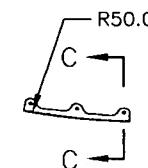
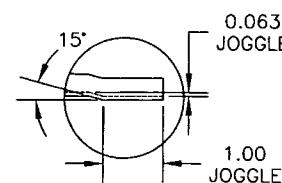
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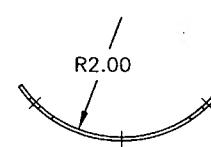
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



RELEASED
07-01-28

NO. 3134

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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA
PH	P4		REV. A DRAWING NO. D3564
CHECKED	APPROVED		SHEET 2 OF 2
DATE	TITLE		SCALE
06.12.18	WEARSHOE		1:8

DART AEROSPACE LTD

Work Order: 311

Description: ~~Below the~~ Wear Pack

Part Number: D

Inspection Dwg: A Rev: A

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	SAD
Date:	07/03/11

Audited by:	<u>BG</u>
Date:	<u>02-03-04</u>

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	